

Date: Wednesday, 3/26/2008 1:51:18 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : R/H STEP ASSY
Job Number : 38219
Estimate Number : 13170
P.O. Number :
This Issue : 3/26/2008 S.O. No. :
Prsht Rev. : NC Part Number : D3724042
First Issue : 1 / Type : LARGE FAB ASSY Drawing Number : D3724 REVB
Previous Run : 37974 Drawing Revision : B
Material :
Due Date : 4/16/2008 Qty: 1 Um: Each
Written By :
Checked & Approved By : JD 08-3-27
Comment : Est Rev:A new issue 08-02-07 DD verified by:
Est Rev:B ecn 1154p 08-03-13 DD verified by:
Est Rev:C ecn 1158 08-03-19 DD verified by:

Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty Part # Description Batch:

1.25 D2622-120C Extrusion

1336923

1329607 → Small Part

Check Material for any Dents or Defects

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D3737-2 as per dwg D3737

2-Cut D3738-2 as per dwg D3738

3-Deburr and bevel ends for welding

SAD 08/03/27

①

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0 D37331 GUSSET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GUSSET

batch 331297

PK 08-03-27 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 1:51:18 PM
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Job Number:



Seq. #: Machine Or Operation: Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3738-1, D3737-1 and D3733-1 as per dwg D3724

2-Grind flush

Handwritten: 08.03.27
08.03.27

6.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 08.03.27 (1)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08.03.27 (1)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: 08.03.27

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08-03-27

10.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

206 Step Endplate

batch B 336520

Handwritten: 08.04.02

11.0 D37281 STEP BRACKET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

PLATE

batch B 38223

Handwritten: mf

12.0 D37291 STEP BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLATE

batch B 37580

Handwritten: mf

Handwritten: 08-04-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: R/H STEP ASSY

Job Number: 38219

Part Number: D3724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D37301

ANGLE



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

ANGLE

batch

B 37843

mf

14.0

D37411

ANGLE



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

ANGLE

batch

B 37762 x (4), B 38224 x (4)

mf

15.0

MS20470AD511

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

batch

M 107100

mf

16.0

MS20470AD516

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch

M 107100

mf 08-04-01

17.0

CR321354

Cherry Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Cherry Rivet

batch

M 107100

mf 08-04-02

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Apply Magnobond before installing rivets

A/R Magnobond 6398 Batch: ~~M 104677~~ M106695.

2-Rivet D3741-1 and D3730-1 to brackets before installing on step as per dwg D3724

3-Transfer holes from D3730-1 and D3741-1 into step as per dwg D3724

4-Deburr

mf

mf 08-04-01

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: R/H STEP ASSY

Job Number: 38219

Part Number: D3724042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Apply magnabond as per dwg D3724

A/R Magnabond 6398 Batch: *M1066695*

6-Rivet brackets in place on step as per dwg D3724

7-Weld both end cap as per Dwg D3724

8-Grind end cap welds flush

Inspect for foreign object per QSI 024

PH 08.04.03 1
PH 08.04.04 1
PH 08.04.07 1
PH 08.04.07 1

19.0

QC10

VISUAL WELDING INSPECTION

M 08/04/07



Comment: VISUAL WELDING INSPECTION

S 08/04/07 *PH 08-04-07 1*

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/07 (X)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-H 08/04/07

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

PH 08-04-07 (1)

23.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PH 08/04/08 (1)

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D3043 and QSI 005 4.4

PH 08/04/08 (2)

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/08 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: R/H STEP ASSY

Job Number: 38219

Part Number: D3724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PP 38215

PC 8/4/10 (1)

27.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 08-04-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

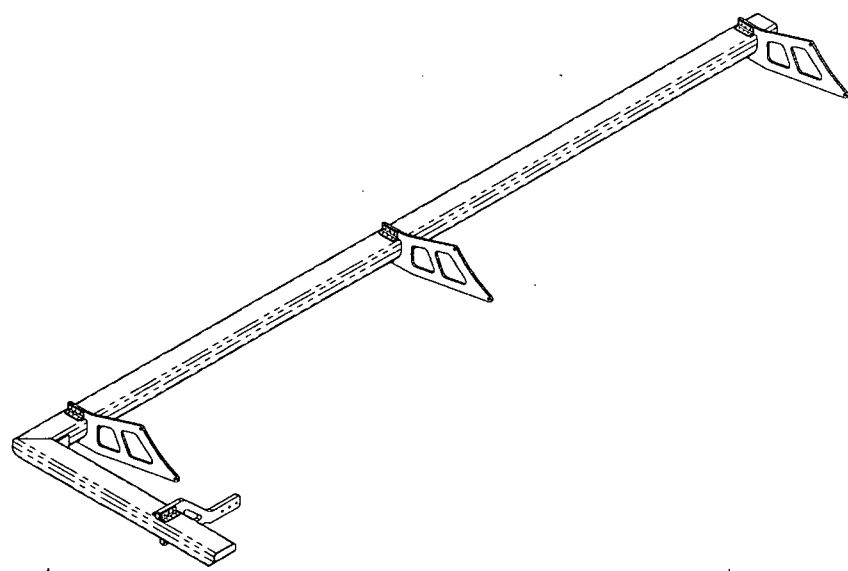
8 7 6 5 4 3 2 1

D

C

B

A



D3724-042 STEP ASSY (SHOWN)
D3724-041 STEP ASSY (OPPOSITE)

NO. 6821
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AGREEMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: CHEMICAL CONVERSION COAT WELDMENT PER DART QSI 005 4.1 PRIOR TO ASSEMBLY
POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PER DART QSI 005 4.4 WHERE INDICATED
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 13.89 lbs
 - 8) WELDING: PER DART QSI 004
 - 9) APPLY MAGNOBOND 6398 BETWEEN MATING SURFACES WHERE INDICATED
 - 10) TOUCH UP CHEMICAL CONVERSION COAT ON ALL PARTS TRANSFER-DRILLED. (REF QSI 005 4.1)

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3724-041	STEP ASSEMBLY
	X	D3724-042	STEP ASSEMBLY
2	2	D2734-1	END PLATE
8	8	D3730-1	ANGLE
1	1	D3733-1	GUSSET
1		D3737-1	STEP
	1	D3737-2	STEP
1		D3738-1	STEP
	1	D3738-2	STEP
1	1	D3747-1	DECAL
32	32	CR3216-5-4	RIVET
12	12	MS20470AD5-11	RIVET
4	4	MS20470AD5-16	RIVET
8	8	D3741-1	ANGLE
3	3	D3728-1	STEP BRACKET
1	1	D3729-1	STEP BRACKET

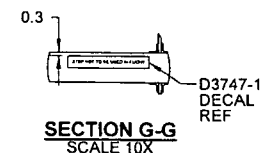
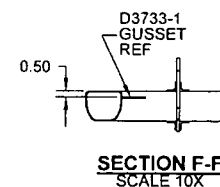
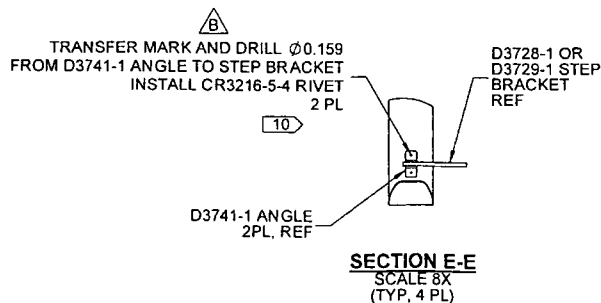
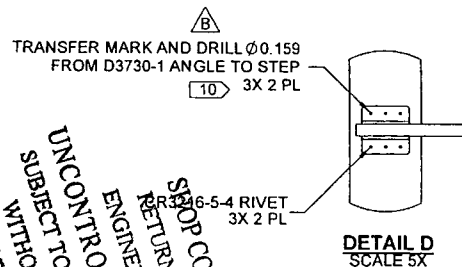
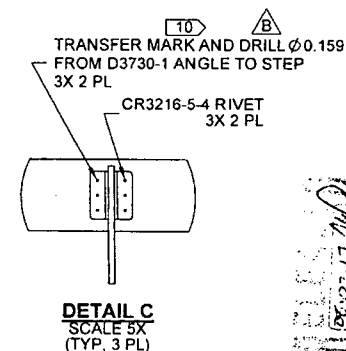
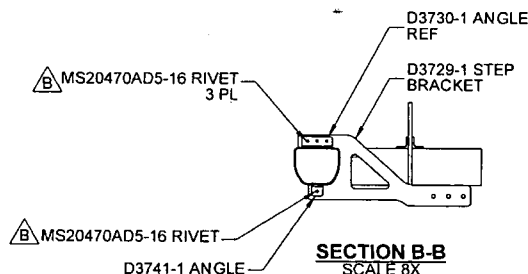
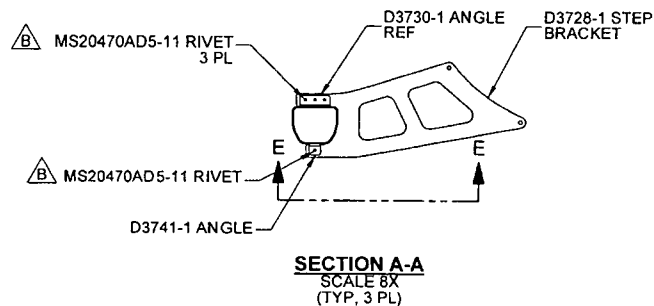
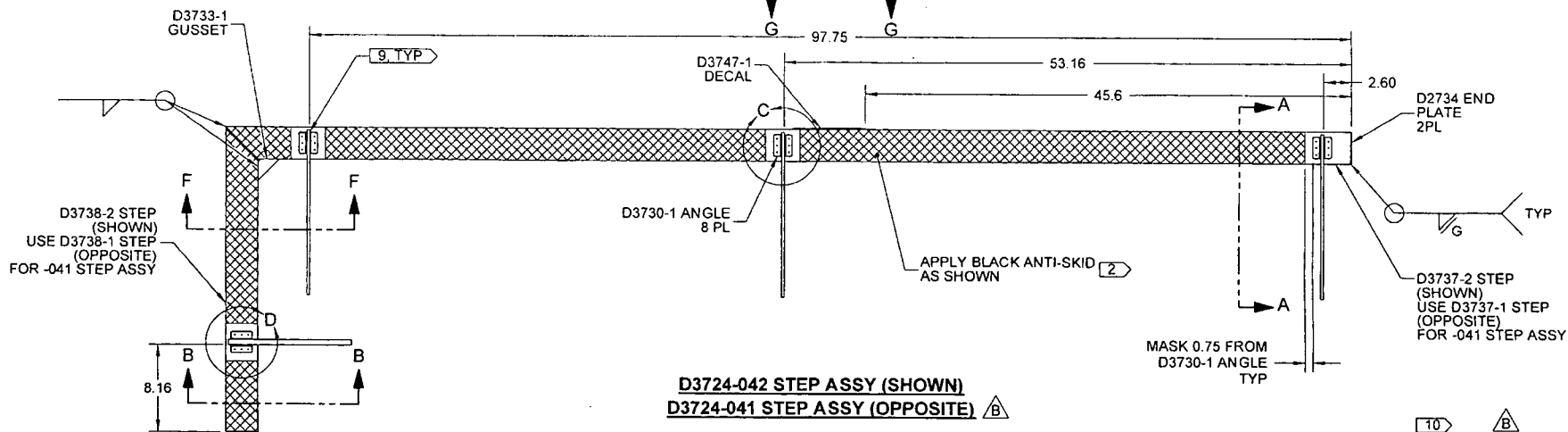
D

C

B

A

B	ADD -041 ASSEMBLY. ADD D3747-1 DECAL TO PL. SHEET 2 TRANSFER MARKING INSTRUCTIONS FOR INSTALLING D3730-1 & D3741-1 ON D3728-1 & D3729-1 DELETED. SHEET 2 DETAIL C, D & SECTION E-E. Ø0.159 WAS Ø0.098. ZONE D4 53.16 DIM WAS 53.22, 2.60 DIM WAS 2.66. ADD SECTION G-G.	AJS	08.02.26
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	LE		
MFG. APPR.	MP		
APPROVED	MP		
DE APPR.		DRAWING NO. D3724 TITLE STEP ASSY	
DATE	08.02.26	REV. B SHEET 1 OF 2 SCALE NTS	
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 WORK ORDER
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